

Work Order ID 79841

79841

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Item ID: D3307-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Access Panel Assembly
 Start Date: 03/02/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 17/02/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/02/06 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3307	Rev A								

100 FLOW WATER JET 0.00
100
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut D3307-1 as per Dwg D3307 Dwg Rev: A Prog
384.032 Rev: A 2-Deburr if necessary

1B12-3-5
 (4)

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00
 Quality Control

1B12-3-8

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00
 Quality Control

517103/05

(XO)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	NC BRAKE								
Brake NC	Memo	0.00							
Brake NC	bend as per dwg D3307								
140		0.00							
140	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1-Bond gasket as per dwg D3307								
150		0.00							
150	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

(4) FF 12-03-06

(4) FF 12-03-06

(4)

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: 233A	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

123105 (4)

MLJ 12/03/08

MLJ 12/03/08
(4)

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 79841

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Parent Item: D3307-041

D3307-041

Parent Item Name: Access Panel Assembly

Start Date: 03/02/2012

Required Date: 17/02/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: A08.08.05New issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3307-3		Manufactured	No			100	Each	2.0000	1	4			

D3307-3

Gasket

**

(4) FF 12-03-06

Location

Loc Qty

Loc Code

ST233A

B 80171

2

3

44725

1

77815

1

1

M304S22GA

Purchased

No

140

sf

29.8600

0.26

1.04

M304S22GA

304/316 .032 Sheet

**

B12-3-5

Location

Loc Qty

Loc Code

MAT020

29.86

109057

3.3

117379

7.06

118271

17

118400

2.5

126866

120866

(4)

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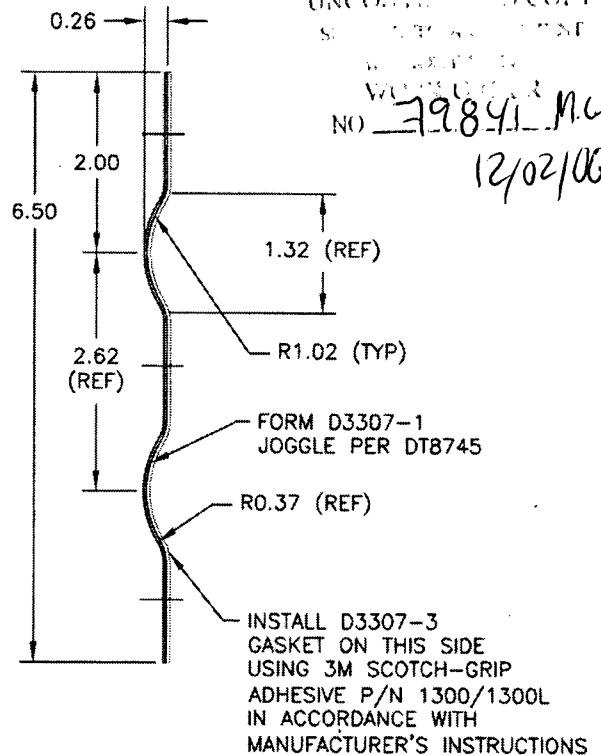
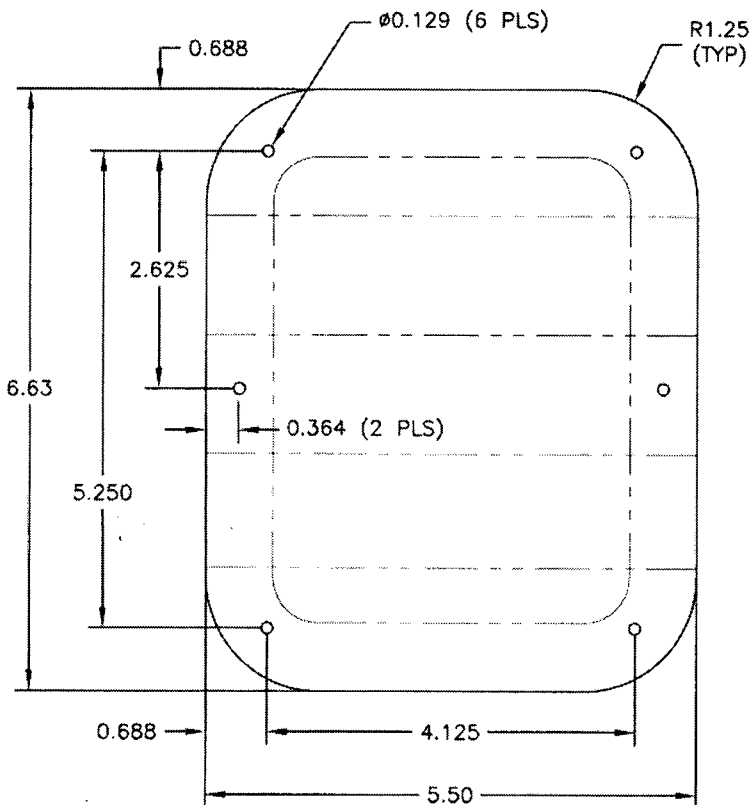


DESIGN 13	DRAWN BY H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3307	REV. A SHEET 1 OF 2
DATE 04.09.23		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:2
A	04.09.23	NEW ISSUE	

RELEASED
05.01.18

SHOWN BY
APPROVED
FOR FILING
UNCONTROLLED COPY
SHEET 1 OF 2

NO 79841 N.C.
12/02/06



D3307-1 PANEL FLAT PATTERN

D3307-041 BEND DETAIL
IDENTIFY WITH P/N & B/N
USING FINE POINT
PERMANENT MARKER

D3307-1 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK ANNEALED (REF. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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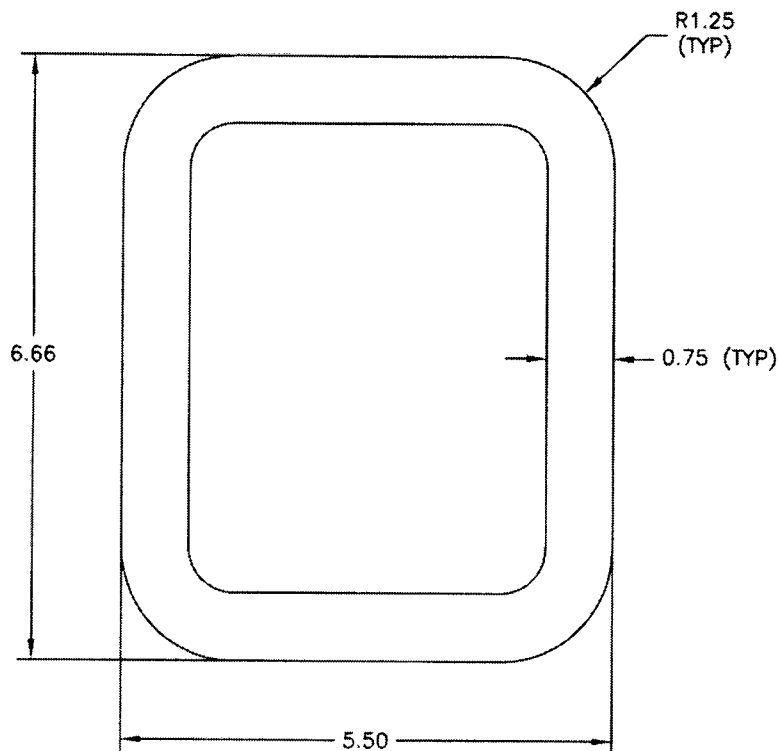
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DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3307	REV. A SHEET 2 OF 2
DATE 04.09.23		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:2

RELEASED
15.01.18



D3307-3 GASKET

D3307-3 NOTES:

- 1) MATERIAL: DURABLE BLACK GASKET 0.035 THICK MIL-A-7021C OR MIL-A-17472B (CLASS 1 & 2) OR MIL-G-12803A (GRADE P-1161A)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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11/18/11

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